

19577



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6521A00138-W142G-3T-

5

Job Sheet 202699



Part No: RBW6521A00138-W142G-3T-5 Job Qty: 3 pcs

Part Name: Ring



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/1/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 11/13/19

Description:

Type: SOLD

Note: DWG RBW6521A00138-W142G-3T Rev 1A IPP Rev. A 19.09.18 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	
100	Conventional Lathe - 1	3 pcs	11/13/19	0.00	1.50	Conventional Lathe - 1	# 11/11/15
						Conventional Lathe - 2	
110	QC 2	3 pcs	11/13/19	0.00	0.00	QC 2 - 1	
						QC 2 - 12	
						QC 2 - 14	
						QC 2 - 17	
						QC 2 - 19	
						QC 2 - 2	
						QC 2 - 20	
						QC 2 - 22	
						QC 2 - 23	
						QC 2 - 25	
						QC 2 - 32	
						QC 2 - 33	
						QC 2 - 35	
						QC 2 - 39	
						QC 2 - 4	
						QC 2 - 40	
						QC 2 - 44	
						QC 2 - 45	
						QC 2 - 48	
						QC 2 - 49	
						QC 2 - 50	
						QC 2 - 51	
						QC 2 - 52	
						QC 2 - 57	
						QC 2 - 62	
						QC 2 - 63	# 11/11/15
						QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	



DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaero.com

Container No: S229501



Part: RBW6521A00138-W142G-3T-5

Job No: 202699

Serial No/Batch: S229501

Revision: 1A

Inspector:

Exp Date:

Instructions:

Date: 11/05/19

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11/1/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
120	QC 8	3 pcs	11/13/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	19/11/06
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
130	Outsource - 4 - Anodize	3 pcs	11/13/19		GRO002-VC	5 2019-11-12
140	Packaging 2-1 - Receive - B4B	3 pcs	11/13/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	NOV 19 2019
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	

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150	QC 6	3 pcs	11/13/19	0.00 0.00	Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					QC 6 - 9	DAS
					QC 6 - 68	NOV 19 2019 68
					QC 6 - 61	9-89
					QC 6 - 40	
					QC 6 - 81	
160	Packaging 3-1 - Stock - B4B	3 pcs	11/13/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170	QC 21 - SA	3 pcs	11/13/19	0.00 0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21 NOV 21 2019 9-89

Part Op 100 - 1-Machine as per DWG. 2-Debur

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check) Engrave T/N and/or P/N using MARKTRONIC engraver as per DWG.

130 - Issue P/O; 45074 - Black oxide finish, MIL-C-13924C Class 1 - Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MIL-C-23411A or MIL-PRF-81309 and wipe off excess. -Material type;

6061T6 - Certificate of Conformity is required

140 - (Pac2-Receive & Inspect for Damage & Mat'l Certs.)

S130-ANODIZE COLOR BLACK, PER TAW MIL-A-8625F

TYPE 2 CLASS 2, WATER SEALANT

MATERIAL TYPE: 6061T6 - CERTIFICATE OF CONFORMITY IS REQUIRED

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11/1/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

150 - (QC6- All purchased or subcontracted products)

160 - (Pac3-Identify as per DWG & Stock Location: _____)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R3.750	6061-T6 Round Bar 3.750"	.2250 ft (.075 ea)	100-Conventional Lathe - 1	S191576

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Conventional Lathe - 1	M6061T6R3.750	0	11	0

Part Specifications

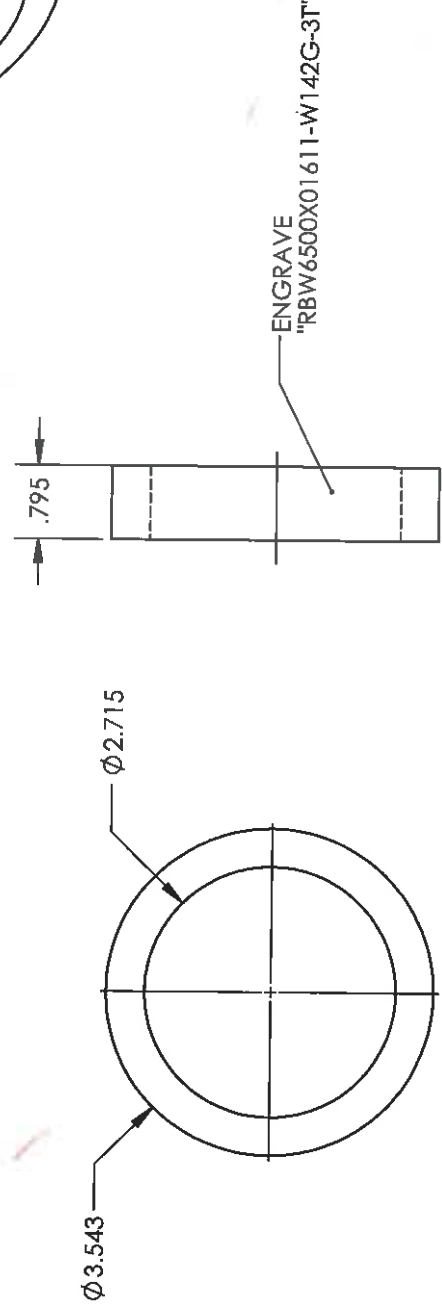
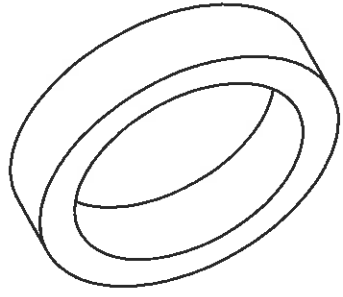
Specifications could not be found.

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REV		REVISIONS	
REV	DESCRIPTION	DATE	INITIAL / APPROVED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 202659 ML5
19-11-01



TITLE		INPUT OIL SEAL REMOVAL PRESS TOOL, IGB INPUT	
DWG NO.		RBW6521A00138-W142G-3T-5	
MATERIAL		6061	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: DUERFELDT	
.XXX ± .005		APPROVED: <u>D. Weil</u>	
.XX ± .01		HEAT TREAT	
.X ± .1		FINISH	
1. BREAK ALL SHARP EDGES .015 x 45°		BLACK ANODIZE	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		SPEC MIL-A-8625F, TYPE II, CLASS II	
SCALE		1:2	
DATE		6/6/2014	
SHEET		4 OF 4	

6 1/2" long total
⑤
RING

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS																																																																																	
		Rework ☐ Scrap ☐ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																																																																																	
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QSI042)																																																																																	
Description Work Order Deviation		Disposition																																																																																			
Root Cause <table border="1"><tr><td>Operator</td><td>☐</td></tr><tr><td>Manufacturing Process</td><td>☐</td></tr><tr><td>Equip/Tooling</td><td>☐</td></tr><tr><td>Handling/Preservation</td><td>☐</td></tr><tr><td>Material</td><td>☐</td></tr><tr><td>Product Improvement</td><td>☐</td></tr><tr><td>Process Improvement</td><td>☐</td></tr><tr><td>Human Factors</td><td>☐</td></tr></table>		Operator	☐	Manufacturing Process	☐	Equip/Tooling	☐	Handling/Preservation	☐	Material	☐	Product Improvement	☐	Process Improvement	☐	Human Factors	☐	FAULT CATEGORY <table border="1"><tr><td>Pressure/Forced</td><td>☐</td><td>Contamination</td><td>☐</td><td>Power Loss/Surge</td><td>☐</td><td>Positioned Wrong</td><td>☐</td></tr><tr><td>Bending</td><td>☐</td><td>Misaligned/off center</td><td>☐</td><td>Folio/Program</td><td>☐</td><td>Outside Tolerance</td><td>☐</td></tr><tr><td>Crushing</td><td>☐</td><td>BOM/Route</td><td>☐</td><td>Grain Direction</td><td>☐</td><td>Drawing</td><td>☐</td></tr><tr><td>Cracks</td><td>☐</td><td>Broken/Damage/Defect</td><td>☐</td><td>Weld</td><td>☐</td><td>Finish</td><td>☐</td></tr><tr><td>Crimp/Kink/Ripple/Wave/Twist</td><td>☐</td><td>Incomplete/Unclear Instructions</td><td>☐</td><td>Wrong Stock Pulled</td><td>☐</td><td>Part Lost/Missing</td><td>☐</td></tr><tr><td>Marks/Chatter</td><td>☐</td><td>Drill Holes</td><td>☐</td><td>Out of Sequence</td><td>☐</td><td>Misread</td><td>☐</td></tr><tr><td>Mislabeled</td><td>☐</td><td>Fit/Function</td><td>☐</td><td>Off-set/Set-up</td><td>☐</td><td></td><td></td></tr><tr><td colspan="2">Other/Details:</td><td colspan="6"></td></tr></table>				Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐	Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐	Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐			Other/Details:							
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Completed By																																																																																					
Lead hand / Supervisor																																																																																					
QC / QA Coordinator																																																																																					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB045074**



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045074

PO Date: 11/12/19

Due Date: 11/20/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-11-12

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	202699	RBW6521A00138-W142G-3T-5	RBW6521A00138-W142G-3T Rev 1A	Ring (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed X6r	-	11/20/19	6 pcs	0 pcs	6 pcs	\$20.00/pcs	\$120.00
Grand Total:												\$120.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Guérin

Plex 11/12/19 10:55 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(024056-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

024056 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.					
15-Nov-2019		Jigar Patel				POHB045074					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)			CATG. U/M	Comm. /Ordered	Exp. Shipped	Quantités / Quantities Qté NC/ NC Qty		Qté Scrap	À venir / Back Order
1	RBW6521A00138-W142G-3T-5 Rev.1A	RBW6521A00138-W142G-3T ANO-BLACK [ANODIZE BLACK] AS PER IAW MIL-A-8625 TYPE - 2, CLASS - 2 WATER SEALANT			ANODIZE CH	6	6	0	0		0

RECEIVED

NOV 18 2019

DART AEROSPACE LTD.

DAS
68
9/89

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 NOV 18 2019
 DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.